

85049

May-31-12 3:41:16 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 31/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 14/06/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 12/06/01

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85049

May-31-12 3:41:16 PM

85049

Page 2

Item ID: D4113-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler Assembly, Baggage Door

Start Date: 31/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

1- C'sink doubler as per dwg
2- Bend doubler as per dwg
3- Install anchor nut, washer and ball stud as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(x6)

(C)

6

8/12/06/20
12/06/20
12/06/21

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85049

Page 3

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Item ID: D4113-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Doubler Assembly, Baggage Door

Stop *NS2*

Start Date: 31/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location

98

0.00

150

Packaging

Memo

0.00

Packaging

6x

50

12-6-21

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/22

ME

12-06-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

May-31-12 3:41:20 PM

Page 1

Work Order ID: 85049

85049

Parent Item: D4113-041

D4113-041

Parent Item Name: Doubier Assembly, Baggage Door

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.09.24 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	271.4720	0.1434	0.603789			

M304S16GA

304/316 Sheet .063

**

B12-G-8

Location	Loc Qty	Loc Code
MAT020	271.472	
121626	143.972	
121889	127.5	

D3622-1 Manufactured No

130 Each 36.0000 1

D3622-1

Ball Stud

**

Location	Loc Qty	Loc Code
ST058	36	
80405	1	
82072	35	

MS20426AD4-5 Purchased No

130 Each 4,731.000 2

MS20426AD4-5

Rivet

**

Location	Loc Qty	Loc Code
ST317	4731	
6874	4731	

MS21069-5 Purchased No

130 Each 49.0000 1

MS21069-5

Anchor nuts

**

Location	Loc Qty	Loc Code
ST302	49	
117504	3	
120465	46	

121889
6
8
12
6

12/06/20
12/06/20
12/06/20

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Picklist Print

May-31-12 3:41:20 PM

Page 2

Work Order ID: 85049

Parent Item: D4113-041

Parent Item Name: Doubler Assembly, Baggage Door

85049

D4113-041

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0563R

Purchased

No

130

Each

393.0000

2

8

NAS1149C0563R

Washer

**

ES 12/06/20

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

193

116391

8

117460

185

12

May-31-12 3:41:20 PM

Shop Packet Print

Page 2

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Dart Aerospace Ltd

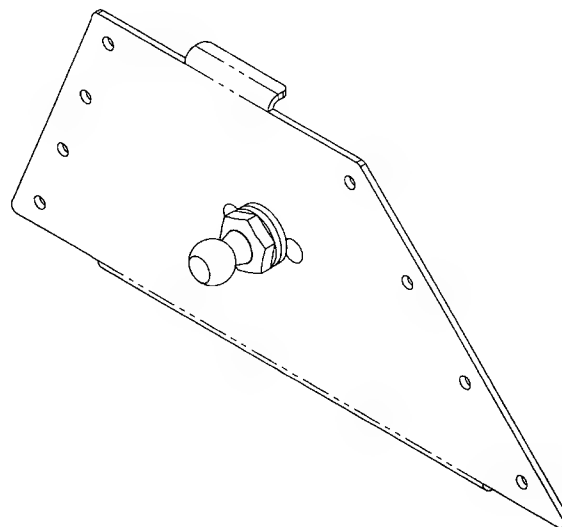
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D4113-041 DOUBLER ASSY. BAGGAGE DOOR

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 85049 ML5
 12/06/01

RELEASED
 2010-09-23
[Signature]

A	NEW ISSUE	JPH	10 07 20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4113	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER ASSEMBLY	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

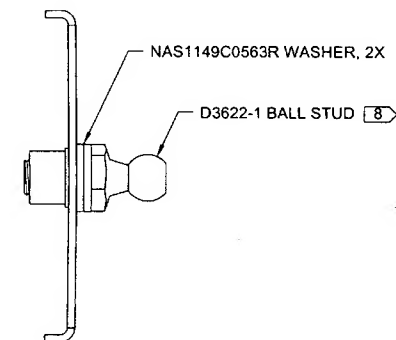
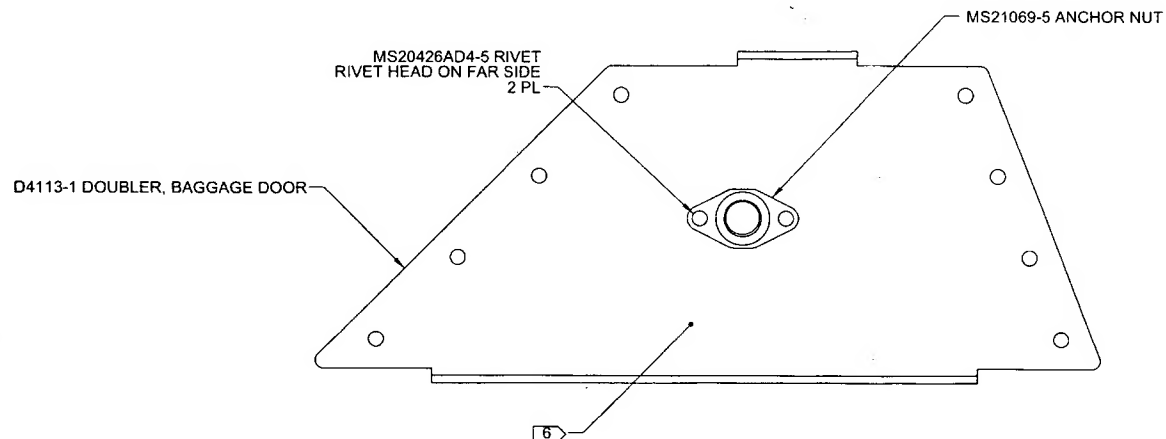
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Qty -041	Part Number	Description
1	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
1	D4113-1	DOUBLER, BAGGAGE DOOR
1	D3622-1	BALL STUD
2	MS20426AD4-5	RIVET
2	NAS1149C0563R	WASHER
1	MS21069-5	ANCHOR NUT



D4113-041 DOUBLER ASSY, BAGGAGE DOOR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENT P/N D4113-041 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) TORQUE TO 15 IN.LB

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4113	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE DOUBLER ASSEMBLY	SCALE NTS
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DATE	10.07.20		

RELEASED
2010-09-23
NR

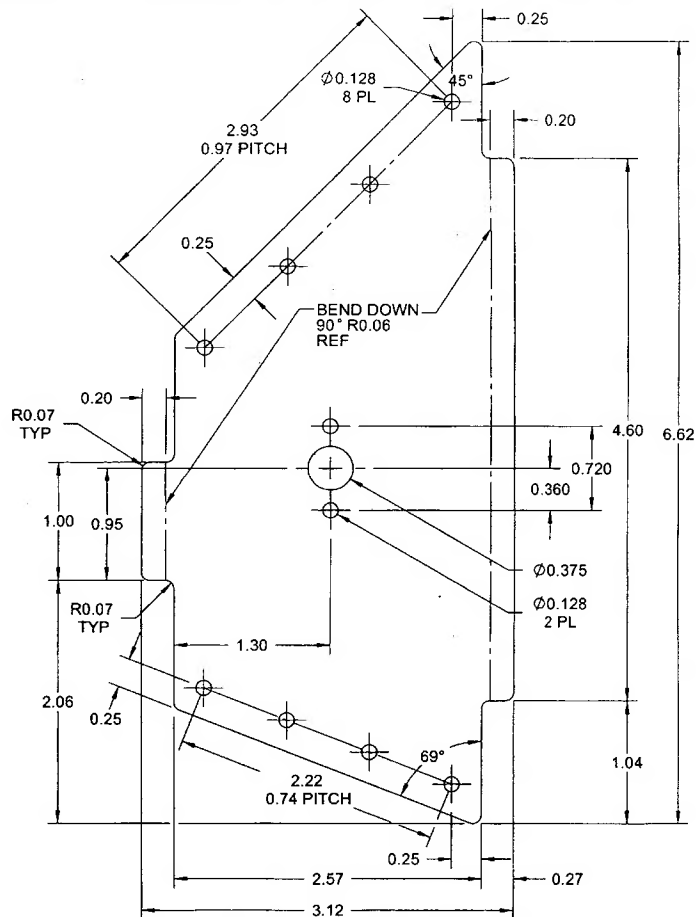
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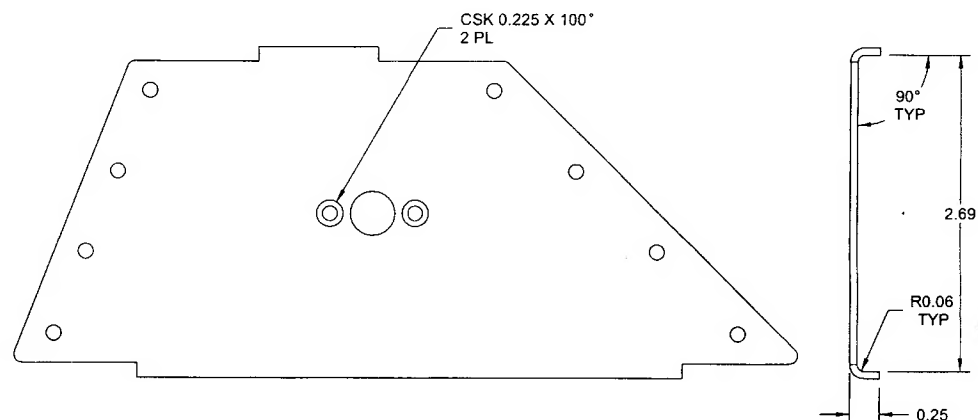
NOTE: Date & initial all entries



D4113-1F FLAT PATTERN, DOUBLER, BAGGAGE DOOR

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1: MAKE FROM D4113-1F
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE.
- 7) WEIGHT: 0.25 lbs



**D4113-1 DOUBLER, BAGGAGE DOOR
(MAKE FROM D4113-1F)**

RELEASED
2010-09-23
MP

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DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4113	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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